

Work Order ID 64543

December 8, 2010 8:29:22 AM



Page 1

Item ID: D3016-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Frame Assembly

Start Date: 12/08/10

Start Qty: 1.00



Cust Item ID:

Required Date: 12/17/10

Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3016

RevA / DEO A-1

100

Weld per dwg A/R 4130 rod Batch: B100075 0.00



Large Fab

Large Fab

Memo

0.00

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Assemble tubes, fittings and weld as per Dwg D3016 using welding jig
DT8597

4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041

5- Assemble brackets and gusset per dwg and weld

10-12-15

x2

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

2 DE 10-12-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8 10/12/16

(42)

130



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

Memo

Install paint screws on fitting ends

START TIME: 3:50

OVEN TEMPERATURE: 320

FINISH TIME: 4:20

0.00

0.00

M112588

2 BL 10-12-16

140



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

jt

10/12/17

2 qt

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Page 3

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Cust Item ID:

Required Date: 12/17/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

Packaging

[Signature]
12/14/10 (2)

160



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/12/2010
[Signature]

mf
10-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

December 8, 2010 8:29:21 AM

Page 1

Work Order ID: 64543

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 12/08/10


Required Date: 12/17/10


Start Qty: 1.00

Required Qty: 1.00


Comments: IPP A 01.09.19 New issue EC IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M4130NT0.750W.049		Purchased	No			100	f	139.1667	4.3	4.526316			
<div style="display: flex; justify-content: space-between;"> <div>  <p>4130 RD Tube .750 x.049W</p> </div> <div> <p><u>Location</u></p> <p>MAT033</p> <p>10133</p> <p>110740</p> </div> <div> <p><u>Loc Qty</u></p> <p>139.1667</p> <p>13</p> <p>126.1667</p> </div> <div> <p><u>Loc Code</u></p> <p></p> </div> </div>													

M4130NT0.500W.049		Purchased	No			100	f	67.3330	4.3	4.526316			
<div style="display: flex; justify-content: space-between;"> <div>  <p>4130 RD Tube .500 x.049W</p> </div> <div> <p><u>Location</u></p> <p>MAT032</p> <p>106651</p> <p>110740</p> </div> <div> <p><u>Loc Qty</u></p> <p>67.333</p> <p>11.75</p> <p>55.583</p> </div> <div> <p><u>Loc Code</u></p> <p></p> </div> </div>													

M4130NT1.000W.120		Purchased	No			100	f	19.0000	1.5	1.578947			
<div style="display: flex; justify-content: space-between;"> <div>  <p>4130 RD Tube 1.00 x .120wall</p> </div> <div> <p><u>Location</u></p> <p>MAT033</p> <p>113665</p> </div> <div> <p><u>Loc Qty</u></p> <p>19</p> <p>19</p> </div> <div> <p><u>Loc Code</u></p> <p></p> </div> </div>													

D3016-17		Manufactured	No			100	Each	4.0000	2				
<div style="display: flex; justify-content: space-between;"> <div>  <p>Gusset</p> </div> <div> <p><u>Location</u></p> <p>WA</p> <p>39641</p> <p>64618</p> </div> <div> <p><u>Loc Qty</u></p> <p>4</p> <p>4</p> <p>2</p> </div> <div> <p><u>Loc Code</u></p> <p></p> </div> </div>													

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 8, 2010 8:29:21 AM

Work Order ID: 64543

Parent Item: D3016-041



Parent Item Name: Seat Frame Assembly



Start Date: 12/08/10



Required Date: 12/17/10

Start Qty: 1.00

Required Qty: 1.00

D3016-13 :  Bracket	Manufactured	No	100	Each	18.0000	2	2	 <u>EL 10-12-15</u>
--	--------------	----	-----	------	---------	---	---	--

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
D3016-15  Gusset	Manufactured	No	WA 44778	18 18	9.0000	2	2	 <u>EL 10-10-15</u>

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
D3020-1  Fitting	Manufactured	No	WA 43413	9 9	41.0000	4	4	 <u>EL 10-12-15</u>

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	41	
36713	41	<u>4</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O BUS43

DEO ATTACHED

RELEASED
01.05.30 *#*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

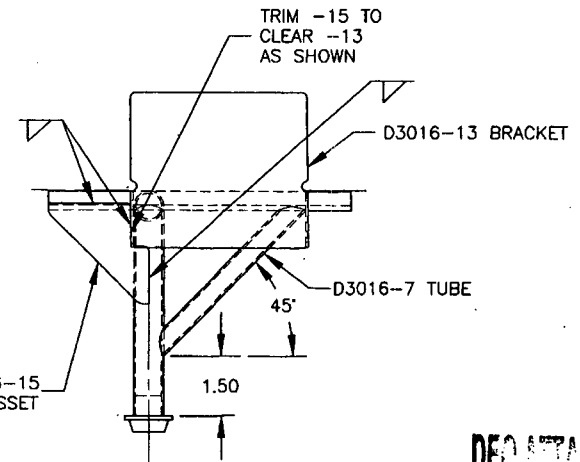
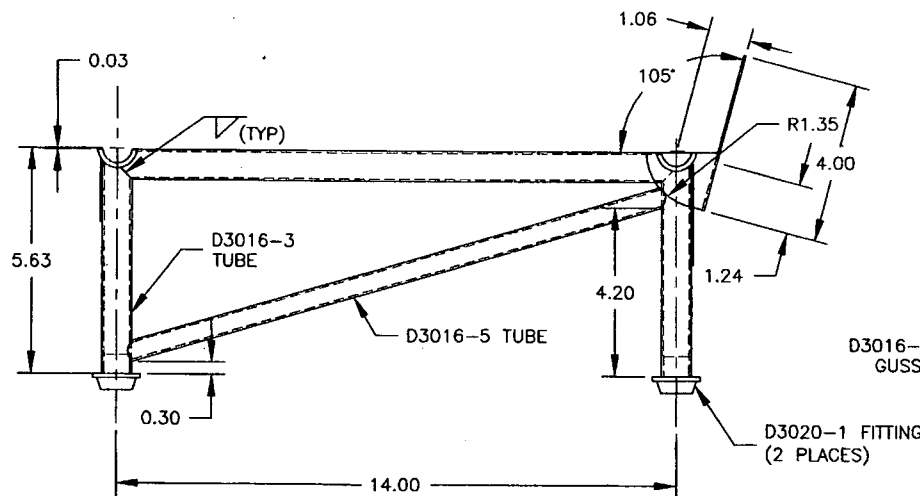
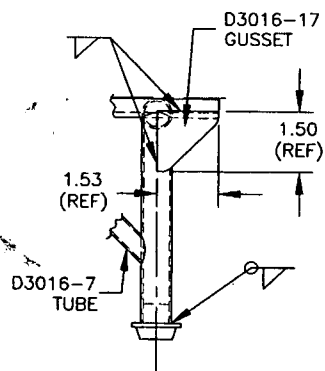
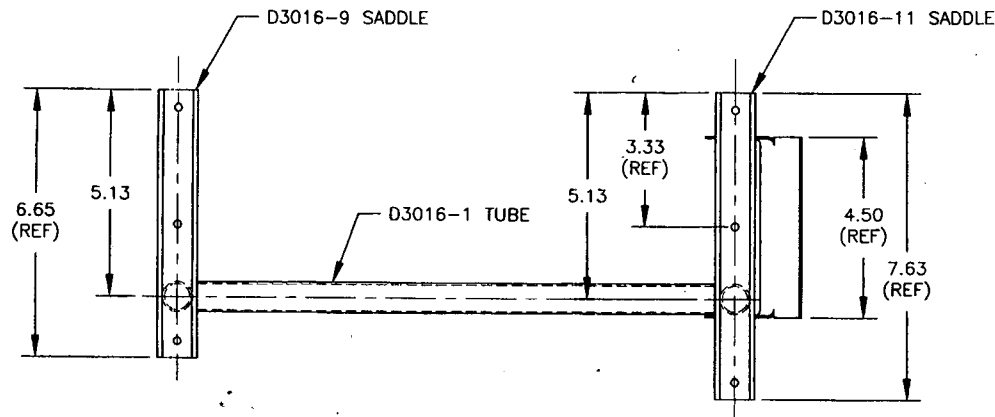
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D3016-041 SEAT FRAME ASSEMBLY



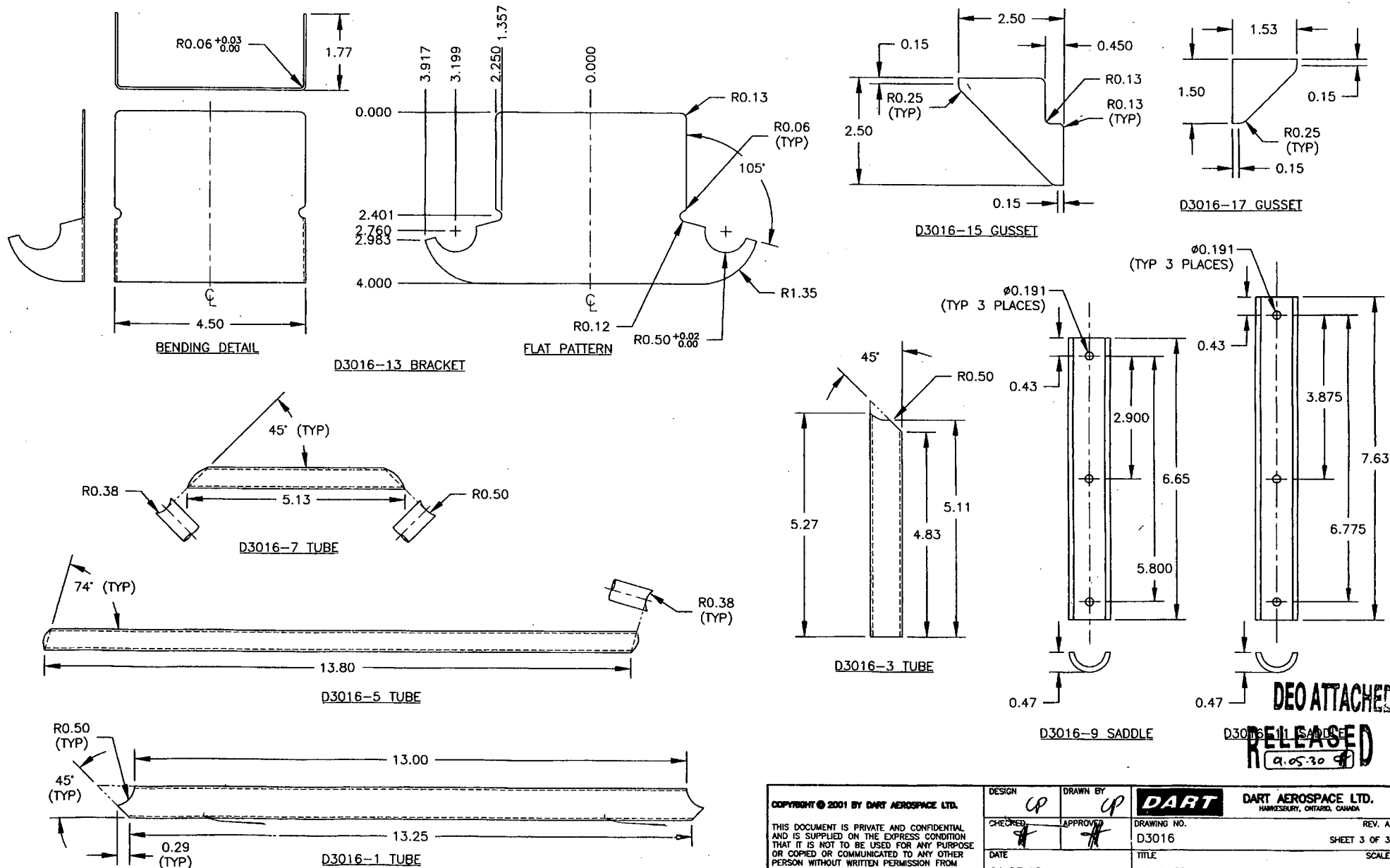
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DESIGN CP	DRAWN BY CP	DART	DART AEROSPACE LTD. WILLOWDALE, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D3016	REV. A
DATE		TITLE	SHEET 2 OF 3 SCALE

u064543



DEO ATTACHED

RELEASED
 9.05.30

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DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY		SCALE 1:2	

64543

DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>1</i>	CHECKED <i>UP</i>	MFG. APPR. <i>RE</i>	APPROVED <i>WJ</i>	DE APPR. <i>WJ</i>		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	

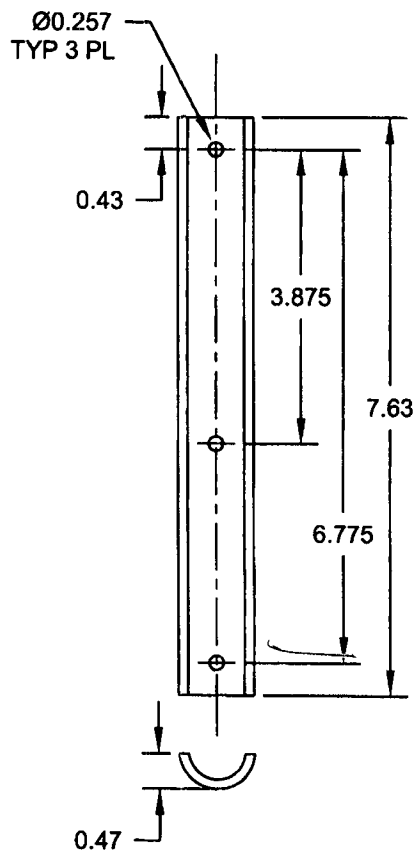
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

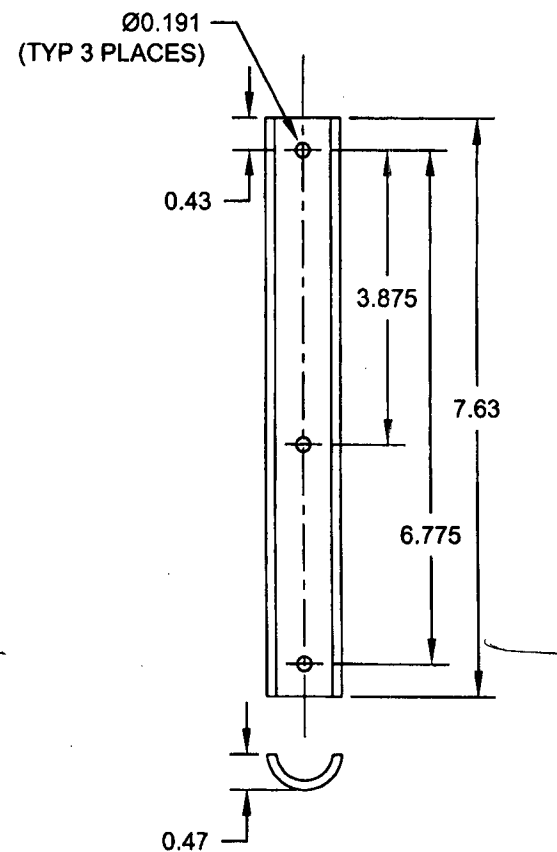
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE